

Work Order ID 61459

Wednesday, August 25, 2010 2:32:00 PM

BLUE



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 8/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-8-25

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D2650	Rev F
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100	0.00
-----	------



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



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Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod *m112507/m114877*

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

BE 10/08/26

BE 10/08/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115



QC5- Inspect part completeness to step on W/O

0.00

5/06/07

QC

Quality Control

116



QC10- Inspect visual per QSI004- ground welds

0.00

5/06/07

QC

Quality Control

120



Chemical Conversion Coat per QSI005 4.1

0.00

DP

10-8-30

HandFinish

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC3- Inspect Part Finish

0.00

1

BE 10/20/20

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

140



Skidtubes

Operation
Description

Skidtubes

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cuttingStart Date: 10/03/10
Time: 11:130 Finish Date: 10/8/11
Time: 7:30am A/R Sikaflex-291 m115116
Sikaflex expiry date: 07/2011 i - BE, 10/03/10

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC5- Inspect part completeness to step on W/O

0.00

8/25/10

XO

QC

Quality Control

160



Skidtubes

0.00

Skidtubes

Skidtubés

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod 11/25/07

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

BT 10/09/02
3 BR 10/09/08

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 9/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



Skidtubes

Operation
Description

HandFinishing

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Memo

Install D2680-041 Nut Plate as per Dwg D2650

3/26 10/09/08

180



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/09/08

0.00

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

f S 10/09/08

0.00



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

200

Operation
Description

Pressure Wash per QSI005 4.3

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

HandFinish

Hand Finishing

Memo

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

205



SprayPaint

Spray Painting

Memo

Spray paint Delfleet Blue
Primer B 114404
Delfleet Blue B 113171
Clear Delfleet B 115506

0.00

ml 10 09 23 (1)

206



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

BT 10-09-24 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

230



HandFinish

HandFinishing

0.00

= M 10/09/22

1 0

Hand Finishing

Memo

0.00

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside
insert holes before installing wearpad/wearplate.A/R Sikaflex-291 1114093Sikaflex expiry date: 10/162-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install
plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291 1114093Sikaflex expiry date: 10/106-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 Batch: 1115028

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S waltz

0.00

250



Packaging

Packaging

Packaging

0.00

JL

0.00

61620

(09/28/11)

260



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-642-441
Location: _____
PPP Rev: _____

10/09/2011

MF
10-9-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, August 25, 2010 2:31:59 PM

Page 1

Work Order ID: 61459



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
 IPP Rev:I 08-05-01 add QC3 DD verified by:EC
 IPP Rev:J 08-09-29 revF as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620 		Manufactured	No			110	Each	4.0000	1	1			
Skidtube, 206 Skidtube													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							LG	4					
							57542	4					
D2646 		Manufactured	No			110	Each	72.0000	1	1			
Aft Cap													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							FP-4	63					
							57332	63	1361752				
							FP6	9					
							52663	9					
D2647 		Manufactured	No			140	Each	72.0000	1	1			
Cap													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							FP	72					
							55352	72					
D2654-7 		Manufactured	No			160	Each	3.0000	1	1			
Web													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							LG	3					
							61264	3					

861455

①

33 10/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

170

Each

472.0000

2

2



Cherry Rivet

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST311	472	
	112314	4	
	113539	44	
	113973	424	

D2649

Manufactured

No

170

Each

29.0000

23

23



BE 10/09/08

Cross Bolt Spacer

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	LG	29	
	58545	2	
	60652	27	

D2680-041

Manufactured

No

170

Each

35.0000

1

1



Nut Plate

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST021	35	
	55366	35	

1

BE 10/09/08

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

230

Each

3,222.000

60

60



Insert



61 10/09/27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

PKG11	3030	
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114723

114723	3030	
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ST282	153	
-------	-----	--

110511

110511	10	
--------	----	--

114407

114407	143	
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ST381	39	
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114654

114654	39	
--------	----	--

X60

AN960JD10L

NAS1149D0332J Purchased

No

230

Each

2,501.000

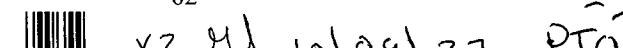
62

62



Washer

11 10/09/27



X2 61 10/09/27 PTO

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST348	2501	
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110985

110985	2501	
--------	------	--

230	Each	0.0000
-----	------	--------

1

1

AN960JD416

NAS1149D04631 Purchased

No

230

Each

0.0000

1

1



Washer

CR3212-4-03

Purchased

No

230

Each

1,912.000

2

2



Cherry Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST311	1912	
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111359

111359	5	
--------	---	--

112314

112314	2	
--------	---	--

114436

114436	448	
--------	-----	--

114450

114450	83	
--------	----	--

114859

114859	1374	
--------	------	--

2

BE 10/09/08

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

WORK ORDER CHANGES

N/O: 101459

WORK ORDER CHANGES						
N/O:	PROCEDURE CHANGE			By	Date	Qty
DATE	STEP				Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/09/27	230	USE NAS11491W352R Qty (60) FOR WEARSHOES B4 <u>MI15698</u> Qty		ML	10/09/27	60
		Perm chg (need to update IIN)		Q	10.09.27	10.09.27 081042
10/10/27	230	USE MS-27031C-1-000 - P14 (60) FOR WEARSHOES.	N/A	Q	10/09/27	10.09.27 081042

Part No: D206-642-441 PAR #:

Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution:

Disposition: _____ QA: N/C Closed: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Resolution: _____		Disposition: _____		QA: N/C Closed: _____		
WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Picklist Print

Wednesday, August 25, 2010 2:32:00 PM

Page 4

Work Order ID: 61459



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

D2651-1



Manufactured No

230

Each

734.0000

22

22



Plug

21 10109127

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	152	
51530	152	
fpa	582	
53349	411	X22
57869	171	

D2651-3



Manufactured No

230

Each

342.0000

22

22



O-Ring

21 10109127

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	342	
46114	342	X22

D3535-15



Manufactured No

230

Each

20.0000

1

1



Wearshoe

21 10109127

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP18	20	
59236	7	
61241	13	Y1

D3535-23



Manufactured No

230

Each

7.0000

1

1



Wearshoe

21 10109127

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP21	7	
60864	7	V1

1361830

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 25, 2010 2:32:00 PM

Page 5

Work Order ID: 61459



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-37



Manufactured No

230

Each

17.0000

1

1



M1 10105127

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	17	
51654	4	
56101	13	

D3536-15



Manufactured No

230

Each

22.0000

1

1



M1 10105127

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	16	
56055	4	
60875	12	
FP11	6	
59238	6	

D3536-23



Manufactured No

230

Each

10.0000



M1 10105127

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	10	
60234	10	

D3536-37



Manufactured No

230

Each

15.0000



M1 10105127

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	15	
56102	15	

Wednesday, August 25, 2010 2:32:00 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 25, 2010 2:32:00 PM

Page 6

Work Order ID: 61459



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

32.0000

6

6



Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	1	
55465	1	
FP017	48	
FP17	31	
57713	3	
60192	3	
60491	25	

1361640

X6

D3537-3

Manufactured No

230

Each

10.0000

1

1

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP19	10	
59711	10	

1360866

1361640

MS27039-1-08

Purchased No

230

Each

1,685.000

2

2

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST291	1685	
110835	493	
114718	192	
115108	1000	

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 25, 2010 2:32:00 PM

Page 7

Work Order ID: 61459



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

230

Each

118.0000

1

1

Screw



MS10109129

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST292	118	
109061	24	X1
115460	94	

MS27039C1-08

Purchased

No

230

Each

802.0000

60

60

SCREW



MS10109127

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	801	
115336	801	X60
ST293	1	
19185	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
1				D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

18/6/159

RELEASED
08.08.08

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/8153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS A TRADE SECRET AND IS RESTRICTED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

8 7 6 5 4 3 2 1

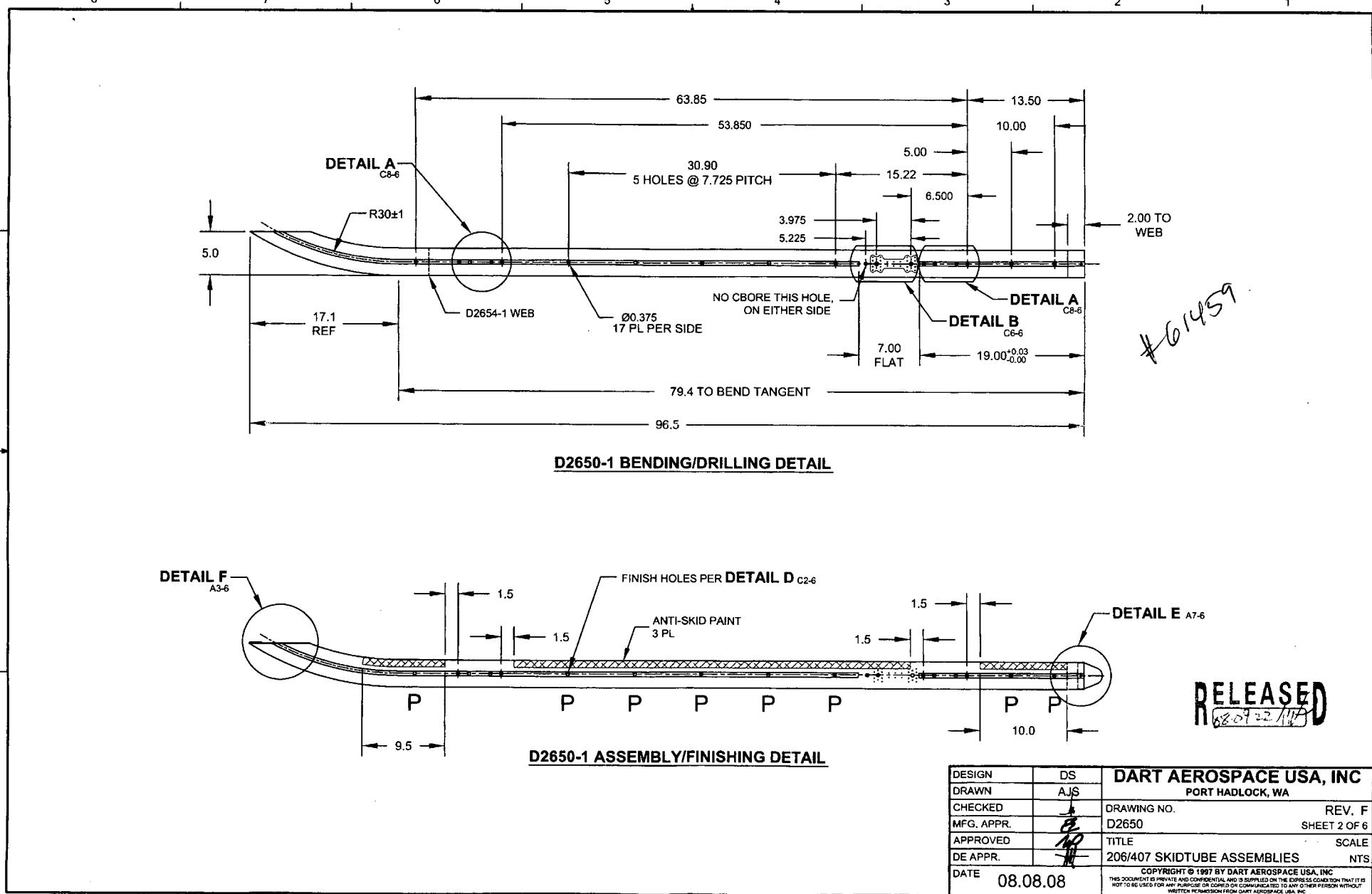
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



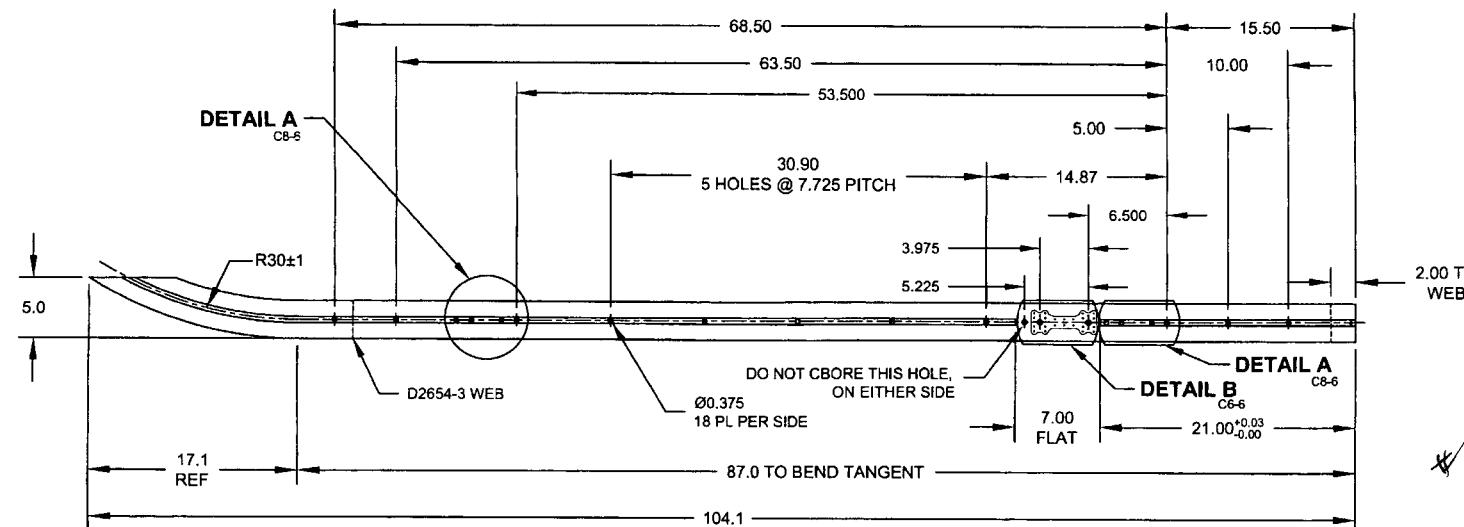
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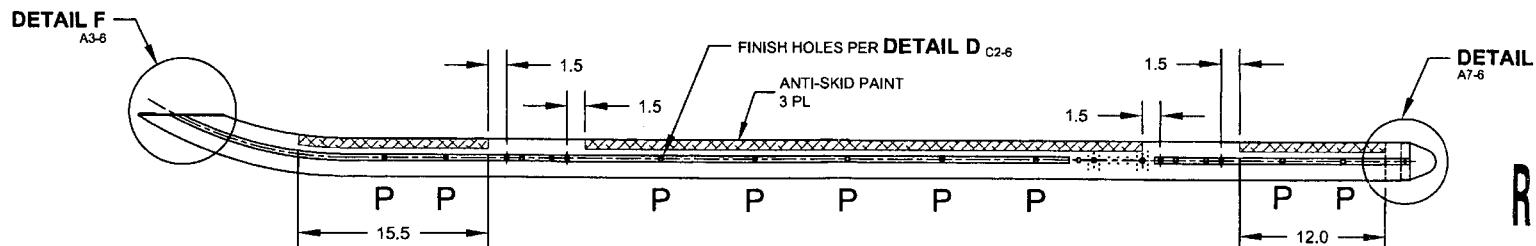
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
05-27-2024

DESIGN	DS	DART AEROSPACE USA, INC		
DRAWN	AJS	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. F	
MFG. APPR.		D2650	SHEET 3 OF 6	
APPROVED		TITLE	SCALE	
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS	
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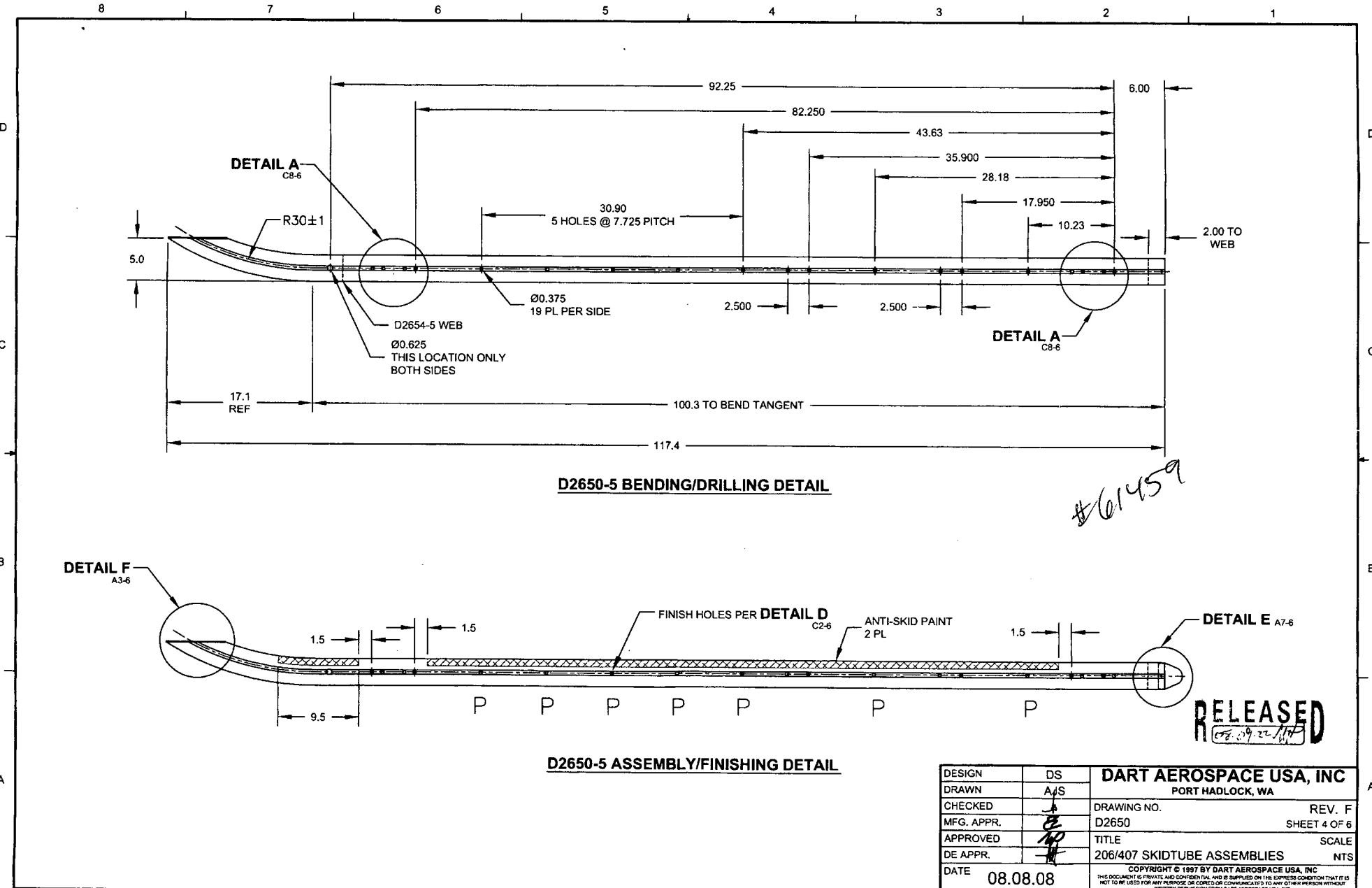
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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.. NOTE: Date & initial all entries



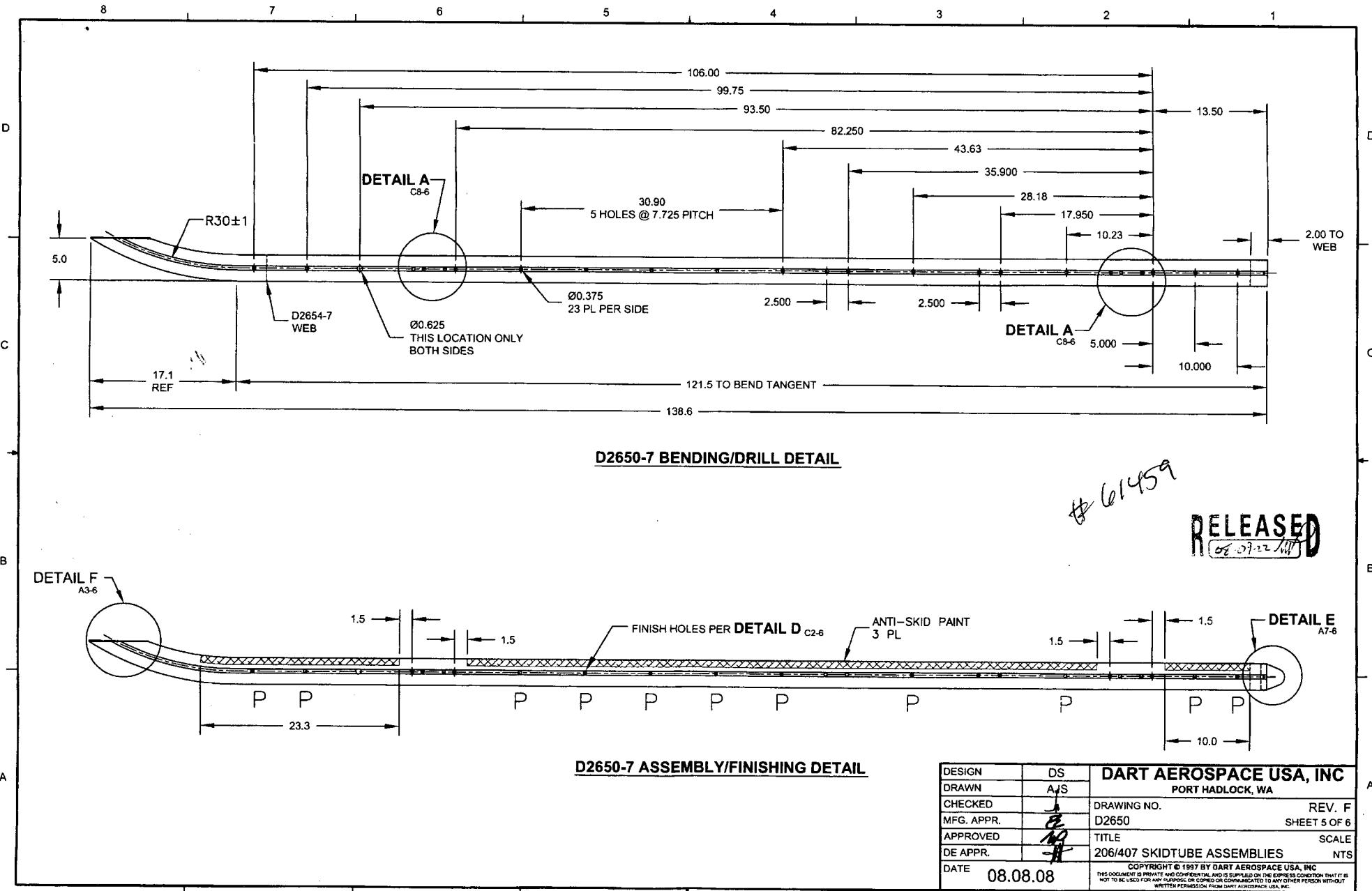
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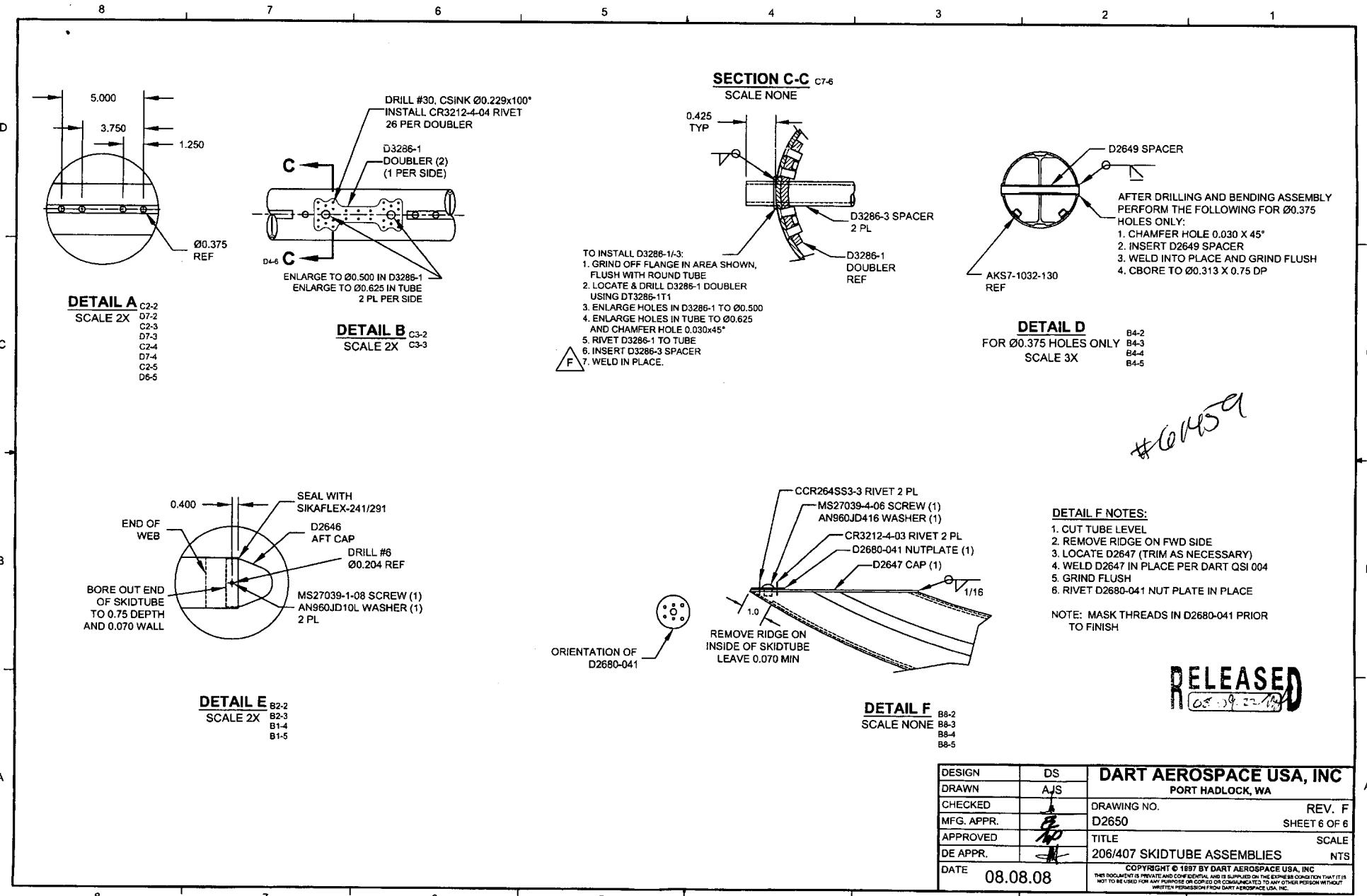
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NOTE: Date & initial all entries



DESIGN	DS	DART AEROSPACE USA, INC
DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO.
MFG. APPR.		REV. F
APPROVED		D2650
DE APPR.		SHEET 6 OF 6
DATE	08.08.08	TITLE
		206/407 SKIDTUBE ASSEMBLIES
		NTS

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08-09-2008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

NO. 251

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 61039
Part number: D206 612-441
Description: 206 skid tube
Welding Process: Tig Mig
Base material: Aluminium
Current: AC DC

TEST REQUIREMENTS AND RESULTS

Visual: pass fail
Penetration: pass fail

UNACCEPTABLE

Cracks: pass fail
Undercut: pass fail
Pin holes: pass fail
Overlap (cold lap) pass fail
Porosity (surface): pass fail
Coloration: pass fail

Qualifier Barclay Elliott Date of Test Coupon 10.08.19
Welder Barclay Elliott Date of Test Coupon 10.08.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld